

Date: Tuesday, 11/6/2007 1:38:08 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT (412 AFT)
Job Number	: 35577		
Estimate Number	: 11060		
P.O. Number	:	Part Number	: D28961
This Issue	: 11/6/2007 S.O. No. :	Drawing Number	: D2896 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 33471	Material	:
Written By	:	Due Date	: 12/13/2007
Checked & Approved By	: <u>11/07</u>	Qty:	12 Um: Each
Comment	Est: B 02.11.26 Reformat; Added P/O; Added mask hole KJ Est Rev: C As per Rev B 07.04.16 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 4996

Description: D6104-011

Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104

Material release note required.

Blank size makes (2) D2896-1

6.50 Round

2.0

D6104011

17-4 SS Round bar 6.50"OD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
Support

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn blank for Haas as per Folio FA167

20 08/04/02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2896-1 PAR #: N/A Fault Category: Prod / Machined Part NCR: (Yes) No DQA: D Date: 08/05/09
 QA: N/C Closed: D Date: 08/05/09

NCR: <u>35577</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.05.02	9	Batch was engraved as Bxxxx. Local area was faced with 0.007" deep pocket and re-engraved	<u>JP</u> 08.05.02 per QS/042	Part OK	<u>JP</u> 08.05.02	<u>(C)</u> 08/05/02	<u>JP</u> 08.05.02 per QS/042	<u>(C)</u> 08/05/02
08/05/04	9	Support #4 dimension AC 3.550 - 3.560 is 3.543	<u>JP</u> 08.05.03 per QS/042	Part OK.	<u>JL</u> 08/05/04	<u>(C)</u> 08/05/04	<u>JP</u> 08.05.03 per QS/042	<u>(C)</u> 08/05/04

NOTE: Date & initial all entries

Date: Tuesday, 11/6/2007 1:38:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT (412 AFT)

Job Number: 35577

Part Number: D28961

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

29 08/04/07

AB

6.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: BAND SAW

Machine as per Folio FA167

Tumble & Deburr

J.L 08/05/04

7.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.L 08/05/04

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

28 08/05/05 (6)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Mask Ø0.625" and face and bore as per Detail D and note 4 hole prior to paint

28 08-05

335577

D28961

06/05/2008

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

28 08-05-00

S.194 12.43

#1 401.8 F

#2 F

#3 30 mins

#4 F

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FX 08/05/06 (2)

12.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime Bore as per QSI 005 4.2.

28 08 05 07

(12)

13.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

5 08/05/07 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/6/2007 1:38:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT (412 AFT)

Job Number: 35577

Part Number: D28961

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

ml 08 05 07

(12)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



ml 08-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35577
Description: Support	Part Number:	D2896-1
Inspection Dwg: D2896 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2896 Rev B/DSK080 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	3.480	3.485		3.484	3.484	3.485	3.485		
B	3.990	4.010		3.995	3.995	3.997	3.995		
C	3.825	3.845		3.835	3.835	3.835	3.835		
D	0.718	0.738		.728	.728	.728	.728		
E	0.090	0.110		.100	.100	.100	.100		
F	3.705	3.725		3.715	3.715	3.715	3.715		
G	1.360	1.380		1.372	1.372	1.372	1.372		
H	1.250	1.260		1.255	1.255	1.255	1.255		
I	6.490	6.510		6.500	6.497	6.497	6.497		
J	0.022	0.042		.032	.032	.032	.032		
K	0.240	0.260		.250	.250	.250	.250		
L	0.107	0.127		.117	.117	.117	.117		
M									
HAAS Section 3 4 5									
AA	2.152	2.172	2.162	2.166	2.171	2.167	2.171		
AB	2.340	2.360	2.350	2.352	2.358	2.344	2.354		
AC	3.550	3.560	3.553	3.558	3.556	3.443	3.555		
AD	3.770	3.790	3.785	3.780	3.778	3.775	3.778		
AE	0.065 x 0.315	0.085 x 0.335	.075/.325	.075/.325	.075/.325	.075/.325	.075/.325		
AF	1.42	1.48	1.450	1.454	1.447	1.451	1.453		
AG	0.833	0.853	.852	.846	.850	.838	.848		
AH	0.240	0.260	.250	.250	.250	.250	.250		
AI	0.261	0.266	.261	.261	.261	.261	.261		
AJ	0.189	0.194	.189	.189	.189	.189	.189		
AK	1.990	2.010	2.008	1.990	2.008	1.999	2.001		
AL	0.625	0.630	.626	.627	.627	.627	.627		
AM	101.75	105.75	103.75	103.75	103.75	103.75	103.75		
AN	0.053	0.073	.063	.063	.063	.063	.063		
AO	0.926	0.946	.945	.946	.946	.938	.944		
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"									
Accept/Reject									

Measured by:	<i>RP</i>
Date:	<i>08/04/02 / 08/05/04</i>

Audited by:	<i>SD</i>
Date:	<i>02/10/05</i>

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	

DART AEROSPACE LTD		Work Order: 35577
Description: Support		Part Number: D2896-1
Inspection Dwg: D2896 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2896 Rev B/DSK080 Rev A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
Lathe Section									
A	3.480	3.485		3.484	3.484	3.485	3.485		
B	3.990	4.010		3.995	3.995	3.997	3.995		
C	3.825	3.845		3.835	3.835	3.835	3.835		
D	0.718	0.738		.725	.728	.728	.728		
E	0.090	0.110		.100	.100	.100	.100		
F	3.705	3.725		3.715	3.715	3.715	3.715		
G	1.360	1.380		1.372	1.372	1.372	1.372		
H	1.250	1.260		1.255	1.255	1.255	1.255		
I	6.490	6.510		6.500	6.497	6.497	6.497		
J	0.022	0.042		.032	.032	.032	.032		
K	0.240	0.260		.250	.250	.250	.250		
L	0.107	0.127		.117	.117	.117	.117		
M									
HAAS Section									
AA	2.152	2.172		2.160					
AB	2.340	2.360		2.355					
AC	3.550	3.560		3.556					
AD	3.770	3.790		3.784					
AE	0.065 x 0.315	0.085 x 0.335		.075 x .325					
AF	1.42	1.48		1.454					
AG	0.833	0.853		.844					
AH	0.240	0.260		.250					
AI	0.261	0.266		.261					
AJ	0.189	0.194		.189					
AK	1.990	2.010		1.995					
AL	0.625	0.630		.627					
AM	101.75	105.75		103.75					
AN	0.053	0.073		.063					
AO	0.926	0.946		.944					
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"									
Accept/Reject									

Measured by: ZC	Audited by: SA
Date: 08/05/04	Date: 08/05/04

Measured by: ZC	Audited by: SA
Date: 08/05/04	Date: 08/05/04

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	

DART AEROSPACE LTD	Work Order: 35571
Description: Support	Part Number: D2896-1
Inspection Dwg: D2896 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2896 Rev B/DSK080 Rev A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
Lathe Section									
A	3.480	3.485		3.484	3.484	3.485	3.485		
B	3.990	4.010		3.995	3.995	3.997	3.995		
C	3.825	3.845		3.835	3.835	3.835	3.835		
D	0.718	0.738		.725	.728	.728	.728		
E	0.090	0.110		.100	.100	.100	.100		
F	3.705	3.725		3.715	3.715	3.715	3.715		
G	1.360	1.380		1.372	1.372	1.372	1.372		
H	1.250	1.260		1.255	1.255	1.255	1.255		
I	6.490	6.510		6.500	6.497	6.497	6.497		
J	0.022	0.042		.032	.032	.032	.032		
K	0.240	0.260		.250	.250	.250	.250		
L	0.107	0.127		.117	.117	.117	.117		
M									
HAAS Section									
AA	2.152	2.172							
AB	2.340	2.360							
AC	3.550	3.560							
AD	3.770	3.790							
AE	0.065 x 0.315	0.085 x 0.335							
AF	1.42	1.48							
AG	0.833	0.853							
AH	0.240	0.260							
AI	0.261	0.266							
AJ	0.189	0.194							
AK	1.990	2.010							
AL	0.625	0.630							
AM	101.75	105.75							
AN	0.053	0.073							
AO	0.926	0.946							
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"									
Accept/Reject									

Measured by: <i>RC</i>
Date: <i>02/10/17</i>

Audited by:
Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	

DART AEROSPACE LTD	Work Order: 35577
Description: Support	Part Number: D2896-1
Inspection Dwg: D2896 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2896 Rev B/DSK080 Rev A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
Lathe Section									
A	3.480	3.485		3.484	3.484	3.485	3.485		
B	3.990	4.010		3.995	3.995	3.997	3.995		
C	3.825	3.845		3.835	3.835	3.835	3.835		
D	0.718	0.738		0.725	0.728	0.728	0.728		
E	0.090	0.110		0.100	0.100	0.100	0.100		
F	3.705	3.725		3.715	3.715	3.715	3.715		
G	1.360	1.380		1.372	1.372	1.372	1.372		
H	1.250	1.260		1.255	1.255	1.255	1.255		
I	6.490	6.510		6.500	6.497	6.497	6.497		
J	0.022	0.042		0.032	0.032	0.032	0.032		
K	0.240	0.260		0.250	0.250	0.250	0.250		
L	0.107	0.127		0.117	0.117	0.117	0.117		
M									
HAAS Section									
AA	2.152	2.172							
AB	2.340	2.360							
AC	3.550	3.560							
AD	3.770	3.790							
AE	0.065 x 0.315	0.085 x 0.335							
AF	1.42	1.48							
AG	0.833	0.853							
AH	0.240	0.260							
AI	0.261	0.266							
AJ	0.189	0.194							
AK	1.990	2.010							
AL	0.625	0.630							
AM	101.75	105.75							
AN	0.053	0.073							
AO	0.926	0.946							
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"									
Accept/Reject									

Measured by: <i>220</i>
Date: <i>08/14/02</i>

Audited by:
Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	

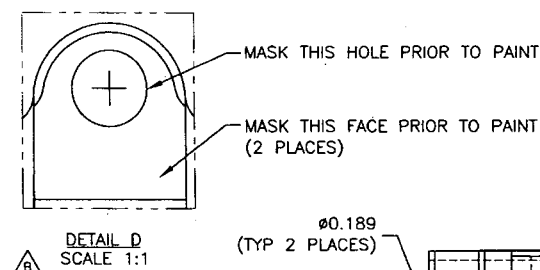
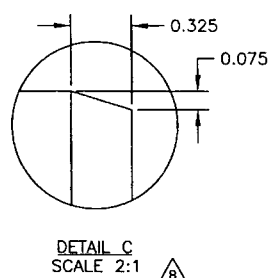
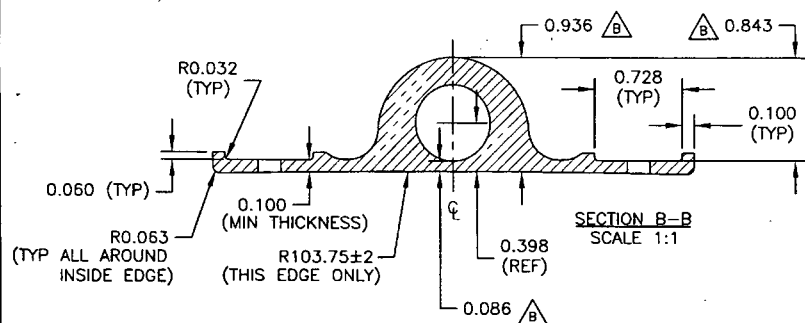
DART AEROSPACE LTD	Work Order: 35577
Description: Support	Part Number: D2896-1
Inspection Dwg: D2896 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2896 Rev B/DSK080 Rev A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
Lathe Section									
A	3.480	3.485		3.484	3.484	3.485	3.485		
B	3.990	4.010		3.995	3.995	3.997	3.995		
C	3.825	3.845		3.835	3.835	3.835	3.835		
D	0.718	0.738		0.725	0.728	0.728	0.728		
E	0.090	0.110		0.100	0.100	0.100	0.100		
F	3.705	3.725		3.715	3.715	3.715	3.715		
G	1.360	1.380		1.372	1.372	1.372	1.372		
H	1.250	1.260		1.255	1.255	1.255	1.255		
I	6.490	6.510		6.500	6.497	6.497	6.497		
J	0.022	0.042		0.032	0.032	0.032	0.032		
K	0.240	0.260		0.250	0.250	0.250	0.250		
L	0.107	0.127		0.117	0.117	0.117	0.117		
M									
HAAS Section									
AA	2.152	2.172							
AB	2.340	2.360							
AC	3.550	3.560							
AD	3.770	3.790							
AE	0.065 x 0.315	0.085 x 0.335							
AF	1.42	1.48							
AG	0.833	0.853							
AH	0.240	0.260							
AI	0.261	0.266							
AJ	0.189	0.194							
AK	1.990	2.010							
AL	0.625	0.630							
AM	101.75	105.75							
AN	0.053	0.073							
AO	0.926	0.946							
Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"									
Accept/Reject									

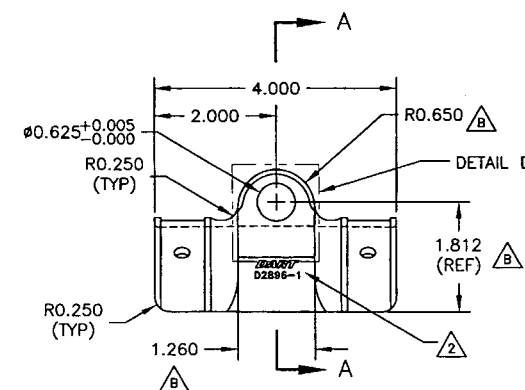
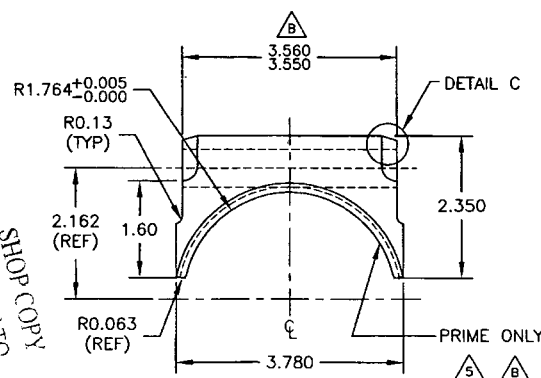
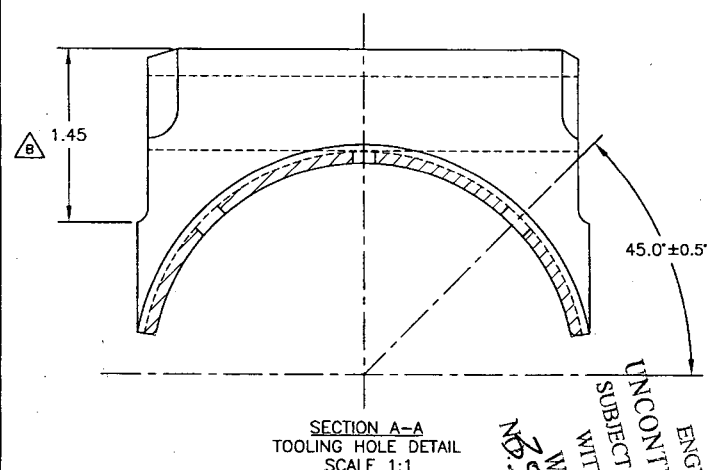
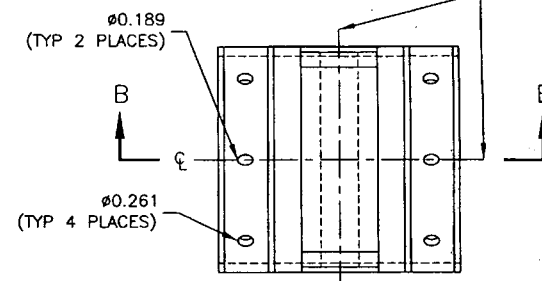
Measured by: <i>RGP</i>	Audited by:
Date: 02/12/13	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	



RELEASED
07.04.12
PER BCN 946

HOLES WITHIN 0.005 OVER ENTIRE LENGTH



D2896-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN THIS AREA
WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2 (B)
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

NO. 5517
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

D2896-1

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DART AEROSPACE LTD.

B	07.03.19	INCORP. A1-A4, FINISHING NOTES
A	01.10.19	NEW ISSUE
DESIGN	GP	DRAWN BY PH
CHECKED	TH	APPROVED TH
DATE	07.03.19	TITLE
		SUPPORT

DART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D2896

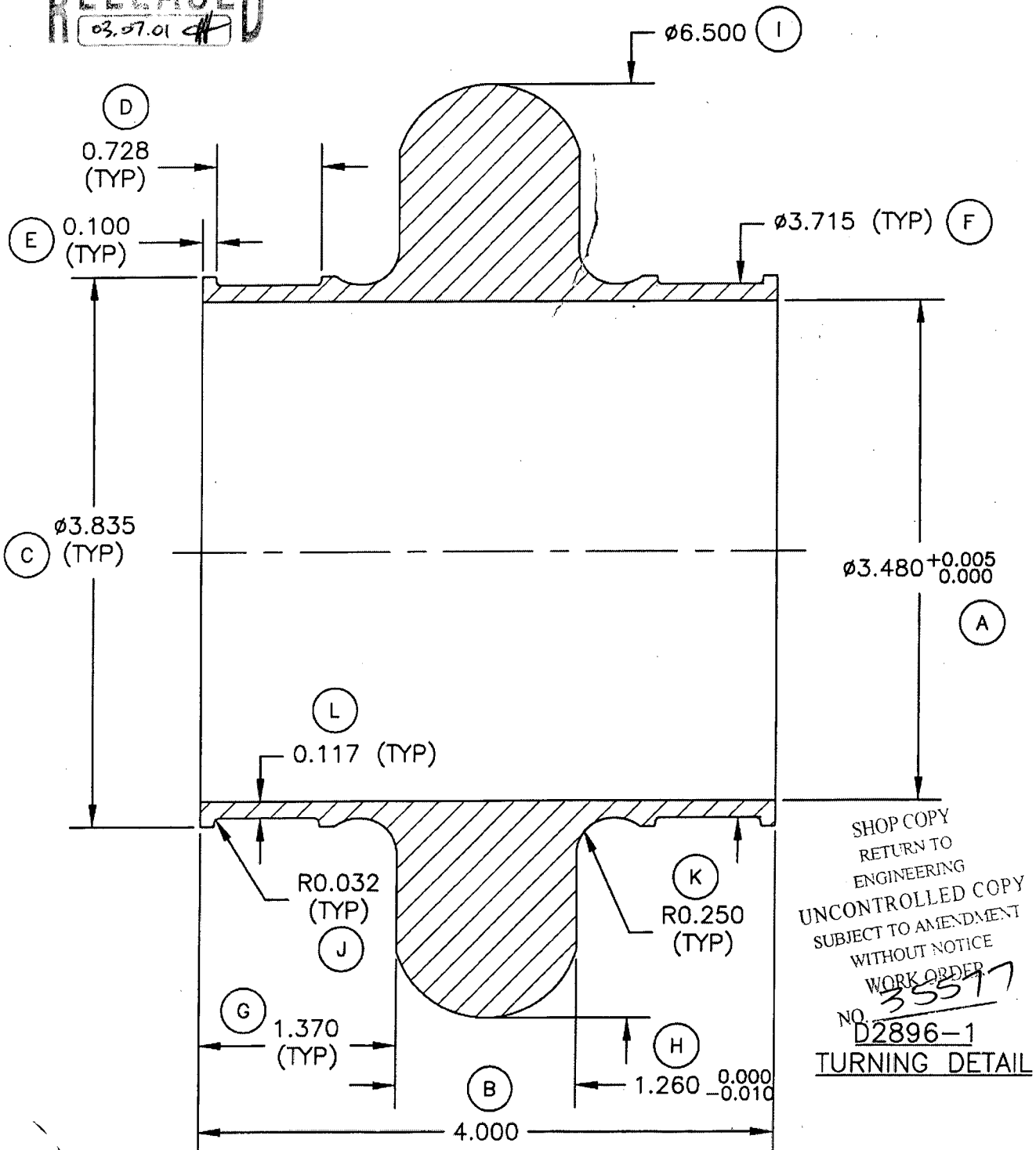
REV. B
SHEET 1 OF 1

SCALE
1:2



DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 080	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2896-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01 [Signature]



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CRUCIBLE
SPECIALTY METALS
A Division of Crucible Materials Corporation
SYRACUSE
NEW YORK 13201

CERTIFICATE OF TEST

S O L D T O	A H CASTLE, INC 3400 N WOLF RD FRANKLIN PARK, IL 60131	S H I P T O	A H CASTLE, INC 26800 HILES RD BEDFORD HEIGHTS OH 44146	OUR ORDER NO. PS-11023-7-0
	DATE 06/08/07			

CUSTOMER ORDER # & DATE 10-30746	CUSTOMER REQ. #	DISTRICT B PARSONS	SHIPPED FROM SYRACUSE
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DESCRIPTION OF MATERIAL

CRU 17-4PH RT A IAC 15003
AMC 3174-02 REV 26 ASME-SA564-04ED T630 ASTM-A564-04 T630
AMS-5643R (EX SURF) AMS-2303E AISI 630 UNS-S17400

SIZE

6.500 RD

HEAT NO.

CHEMICAL ANALYSIS

HEAT NO.	C	MN	P	S	SI	NI	CR	MO	CU	CB	TA
A18738	.045	.36	.030	.020	.53	4.09	15.40	.13	3.12	.28	.010

CASTLE METALS CORP.

DATE RCVD

IAC

APPROVED BY

QUANTITY

HEAT NO.

MECHANICAL PROPERTIES

8770 # A18738 TENSILE PSI YLD.2%PSI %ELONG4D RED/AREAZ HARDNESS
BHN 343/ 345
CAPABILITY PHYSICALS AFTER 900 DEG. F. - 1 HR. AIRCOOL:
204,180 179,610 12.9 48.2 BHN 415

MACRO TEST OK
FERRITE 1 %
MAGNAFLUX F/S = 0/0

REDUCTION RATIO: 7.6:1

MATERIAL SOLUTION TREATED AT 1900 DEG. F. HELD 3 HRS 30 MINS AT TEMPERATURE -
AIRCOOLED.

CRUCIBLE MATERIALS CORP. VENDOR #18610.

MATERIAL INGOT CAST.

NAFTA - YES

MATERIAL FREE FROM MERCURY CONTAMINATION AT TIME OF SHIPMENT
NO WELD REPAIR PERFORMED
MATERIAL MELTED IN U.S.A.

THANK YOU FOR SELECTING A QUALITY PRODUCT

MANUFACTURED BY THE EMPLOYEES OF CRUCIBLE SPECIALTY METALS IN

SWORN TO AND SUBSCRIBED BEFORE ME THIS

DAY OF , 20

NOTARY PUBLIC

CERTIFIED BY:

THE ABOVE MATERIAL WAS MANUFACTURED AND TESTED IN ACCORDANCE WITH ABOVE SPECIFICATIONS AND IS IN CONFORMANCE WITH THE SPECIFICATION REQUIREMENTS.

CRUCIBLE MATERIALS CORPORATION
ACTING BY AND THROUGH ITS SPECIALTY METALS DIVISION

QUALITY ASSURANCE REPRESENTATIVE

I. J. WOOLSON - QUALITY ASSURANCE REPRESENTATIVE

